

Work Order ID 79147***79147***

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January-20-12 1:44:20 PM

Item ID: D4207-1

Accept

N9000040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Window Retainer

Start Date: 20/01/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 03/02/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: M.C.J Date: 12/01/20 Tooling:

Date:

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4207

A

100

0.00

100

Waterjet

Memo

0.00

FLOW CNC Waterjet

2021.040

1-Cut as per Dwg

Dwg Rev: AProg Rev: A

2-Deburr if necessary

B12-2-146

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

B12-2-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 79147

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Page 2

Item ID: D4207-1

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Item Name: Window Retainer

Start Date: 20/01/2012 Start Qty: 4.00

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Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120 QC8- Inspect parts - second check 0.00

120

QC

Memo

Quality Control

0.00

130 Chemical Conversion Coat per QSI005 4.1 0.00

130

HandFinish

Memo

Hand Finishing

0.00

135 QC3- Inspect Part Finish 0.00

135

QC

Memo

Quality Control

0.00

8/2/2014

ey

4 12-2 H.

4x0 M/12/02/14

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Work Order ID 79147

January-20-12 1:44:20 PM

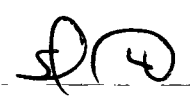
79147


Page 3

Item ID: D4207-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Window Retainer
 Start Date: 20/01/2012 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 03/02/2012 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Identify as per dwg & Stock Location: <u>137</u>	0.00							
140									
Packaging	Memo	0.00							
Packaging									
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.00							
Quality Control									

12/2/15 

12/2/15 

MF
12-02-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Page 1

Work Order ID: 79147

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Parent Item: D4207-1

D4207-1

Parent Item Name: Window Retainer

Start Date: 20/01/2012

Required Date: 03/02/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 11.03.09 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.040		Purchased	No			100	sf	134.3184	1.148	4.833684			

M2024T3S 040

2024-T3 .040 sheet

**

IB12-2-14

Location

Loc Qty

Loc Code

MAT022

134.318421

117684

26.318421

120196

108

120196

4

W/O:		WORK ORDER CHANGES					
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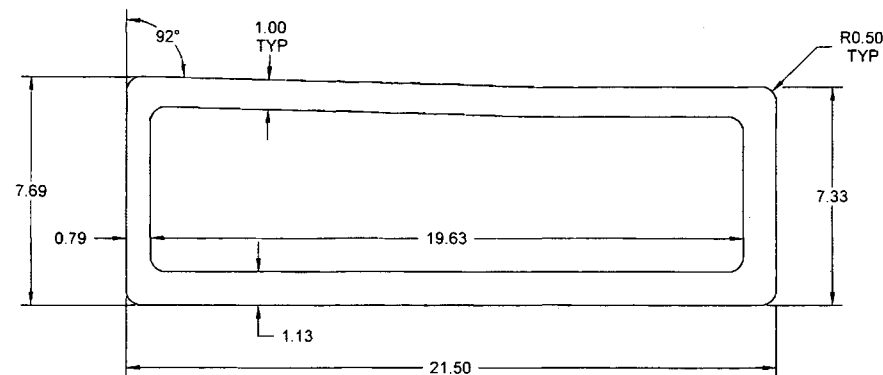
W/O:		WORK ORDER CHANGES					
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D4207-1 WINDOW RETAINER
(REF. EAGLE DRAWING No. D2046902 P/N EA20469-14)

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.040 THICK
QQ-A-250/4 OR AMS-QQ-A-250/4
OR AMS 4037
OR ASTM B209
PER DART SPEC M2024T3S.040
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.22 lbs

RELEASED
2011-04-06

A		NEW ISSUE	RF	10.11.22
REV.	DESCRIPTION		BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	RF			
CHECKED	RF	DRAWING NO. D4207	REV. A	
MFG. APPR.	RF	SHEET 1 OF 2		
APPROVED	RF	TITLE VRD PARTS	SCALE	
DE APPR.	RF	NTS		
DATE	10.11.22	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		

W/O:		WORK ORDER CHANGES					
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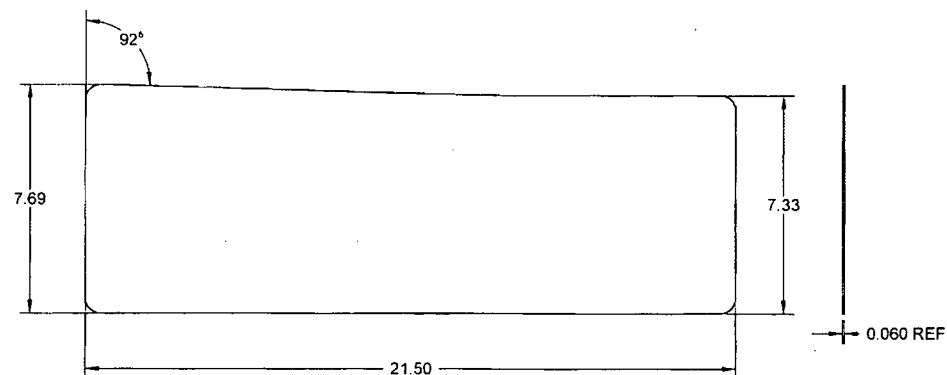
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

79147



D4207-3 INSTRUMENT WINDOW
(REF. EAGLE DRAWING No. D2046902 P/N EA20469-13)

RELEASED
2011-04-06
JW

NOTES:

- 1) MATERIAL: GE PLASTICS LEXAN, 0.060 THICK, SMOOTH, CLEAR SHEET
REF DART SPEC. MLEXS.060-9034-08 OR MLEXS.060-9034-01
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.41 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED.	<i>[Signature]</i>	DRAWING NO. D4207	REV. A
MFG. APPR.	<i>[Signature]</i>	SHEET 2 OF 2	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	VRD PARTS	NTS
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